Date: Tuesday, 4/25/2006 7:36:07 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: HANDLE WELDMENT
Job Number	: 26806		
Estimate Number	: 12089		
P.O. Number	: N/A	**Part Number**	: D3355041
This Issue	: 4/25/2006 **S.O. No.** : N/A	**Drawing Number**	: D3355 REV.A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: A
Previous Run	: N/A	**Material**	: N/A
Written By	:	**Due Date**	: 5/31/2006 **Qty:** 4 **Um:** Each
Checked & Approved By	: 06.04.25		
Comment	: est rev A 06.01.23 new issue EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	VA2160	SNAP BUTTON
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) SNAP BUTTON batch: M17355 06.05.03 CPL (4)	
2.0	GP1R	Black Vinyl Grip
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Black Vinyl Grip batch: M16871 06.05.03 CPL (4)	
3.0	D3355047	ADJUSTABLE EXTENSION
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) ADJUSTABLE EXTENSION B26924 batch: ~~[illegible]~~ CPL 06.08.21 (4)	
4.0	D3355045	BOTTOM PART
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BOTTOM PART batch: ~~[illegible]~~ B26925 CPL 06.08.21 (4)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D3355 CPL 06.08.21 (4)	

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes (No) DQA: [illegible] Date: 02/08/07

QA: N/C Closed: _____ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 4/25/2006 7:36:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HANDLE WELDMENT

Job Number: 26806
Part Number: D3355041

Job Number:

Seq. #:	Machine Or Operation:	Description :	
6.0	QC5	INSPECT WORK TO CURRENT STEP	06.08.21 (4)
	Comment: INSPECT WORK TO CURRENT STEP		
7.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 351		6/8/21 (4)
8.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL Inspection Level 21		06.08.22

Job Completion

06.08.22

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: __________________ PAR #: _______ Fault Category: _______________ NCR: Yes No DQA: _____ Date: _________

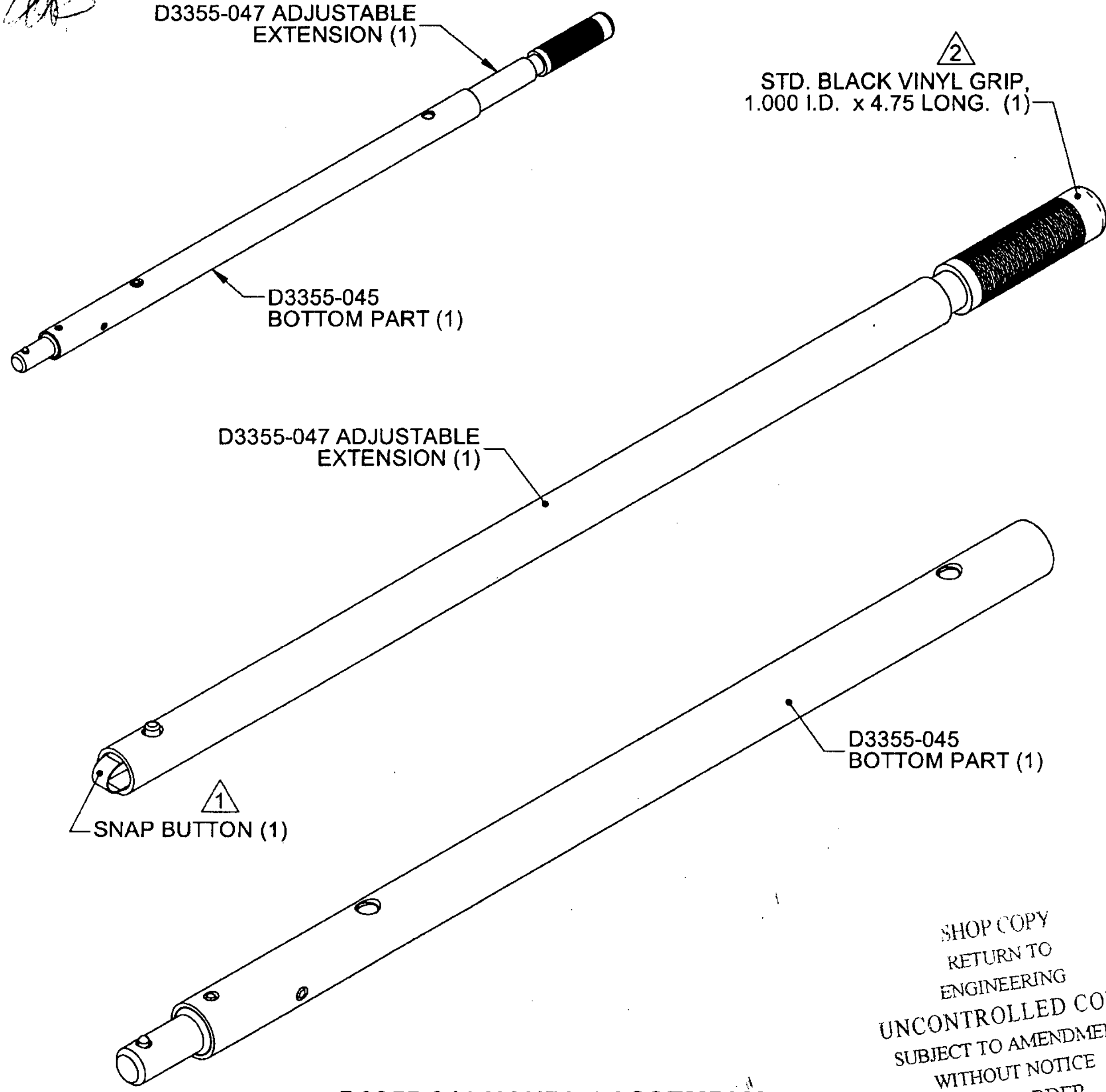
QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN RF	DRAWN BY RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 1 OF 6
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	

DART



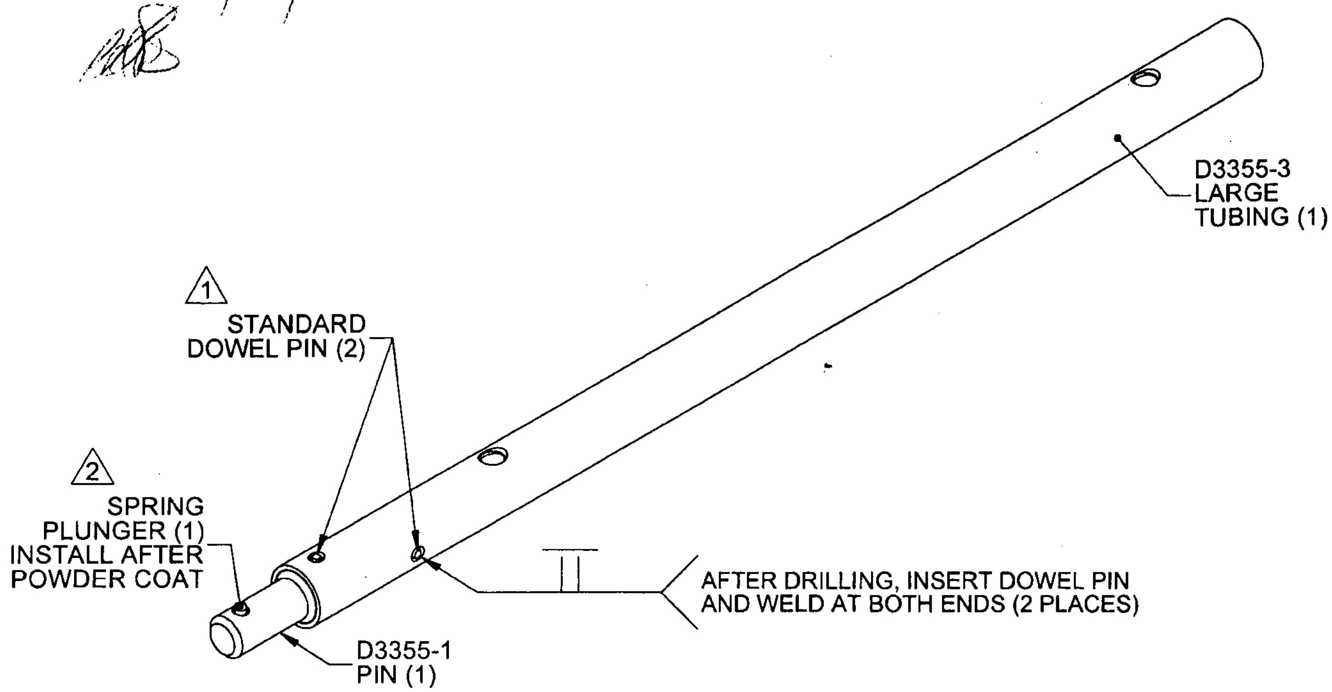
D3355-041 HANDLE ASSEMBLY

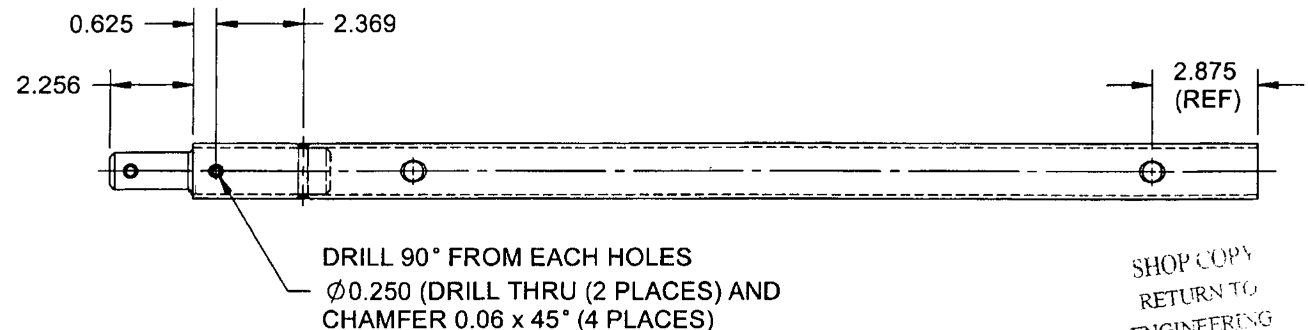
NOTES:

1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

DESIGN RF	DRAWN BY RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 2 OF 6
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5

RELEASED 05/03/07





SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 26806

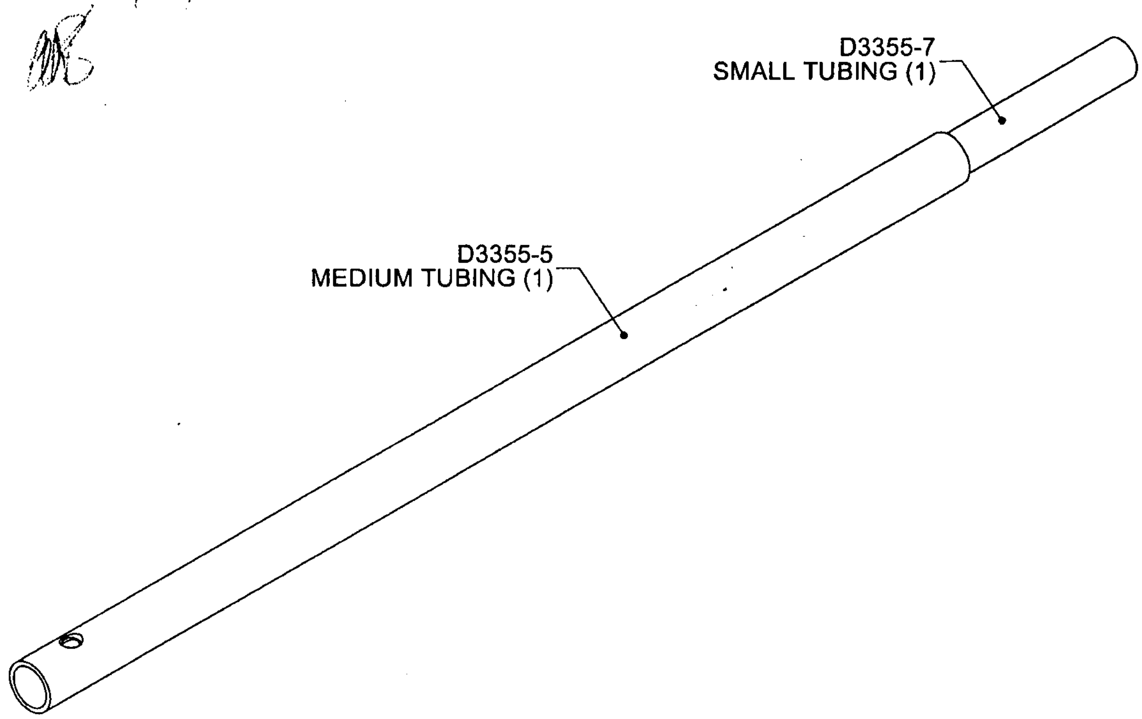
D3355-045 BOTTOM PART

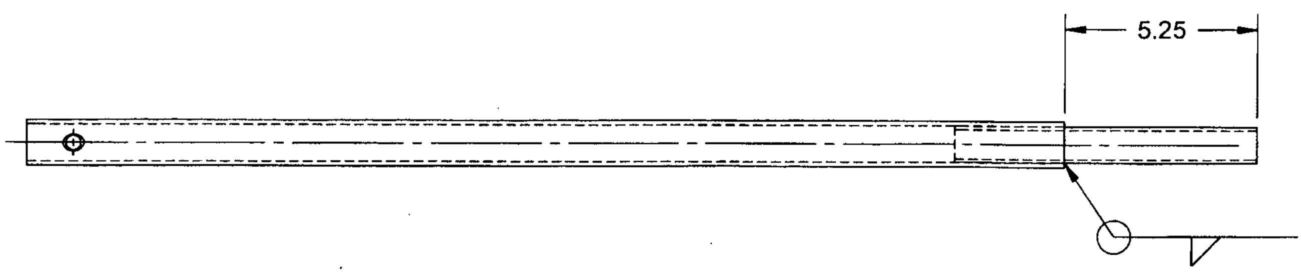
NOTES:

1) STEEL STANDARD GROUND DOWEL PIN, ∅0.250 X 1.50 LONG
   POSSIBLE SUPPLIER: SPAENAUR, P/N 238-~~043~~ 042
2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.010 TO 0.020

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	RF		
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 3 OF 6
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5

RELEASED





D3355-047 ADJUSTABLE EXTENSION

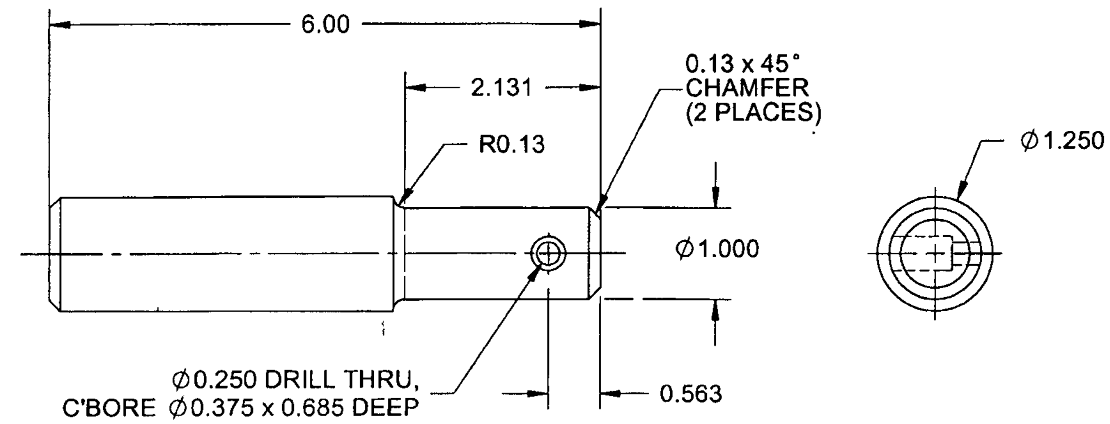
NOTES:

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.010 TO 0.020

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	RF		
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 4 OF 6
DATE	05.02.07	TITLE HANDLE WELDMENT	SCALE 1:2

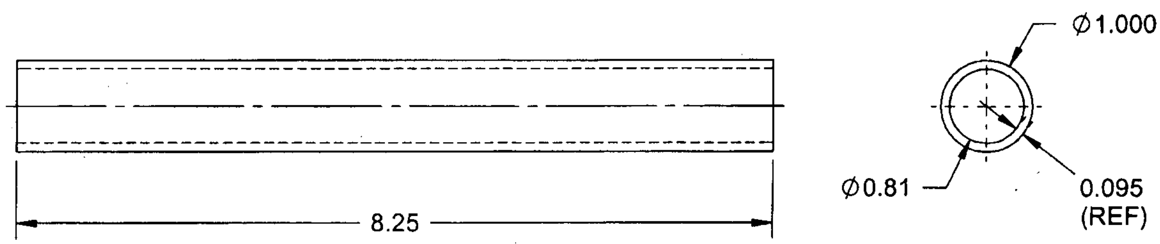
RELEASED



D3355-1 PIN

D3355-1 NOTES:

1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020



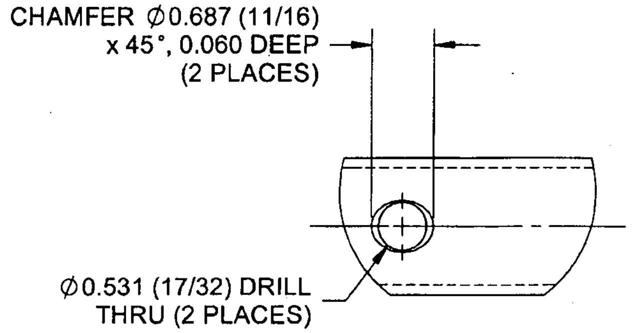
D3355-7 SMALL TUBING

D3355-7 NOTES:

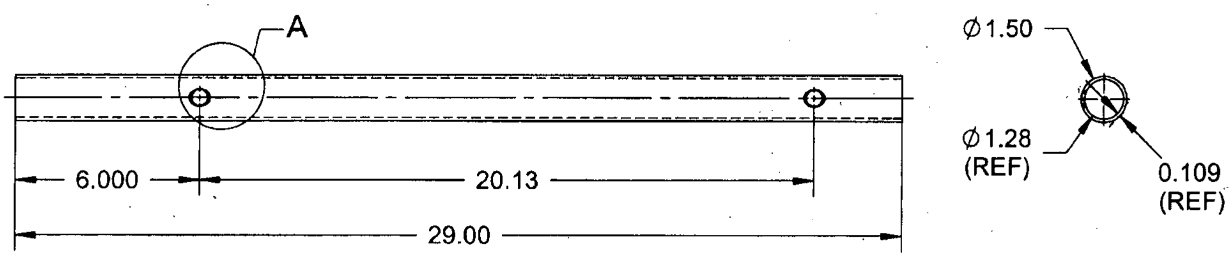
1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	RF		
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 5 OF 6
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:6

RELEASED 06/03/09



DETAIL A
SCALE 1 : 2



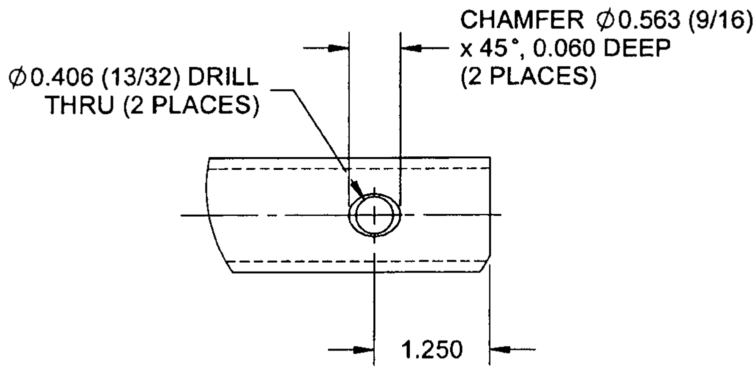
D3355-3 LARGE TUBING

NOTES:

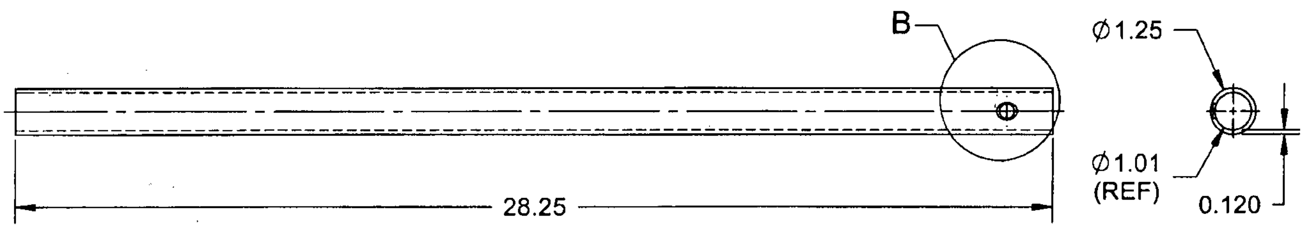
1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.500W.109)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.015 TO 0.030

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 6 OF 6
DATE	05.02.07	TITLE HANDLE WELDMENT	SCALE 1:5

DART



DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.015 TO 0.030